

Work Order ID 62309

Friday, September 24, 2010 3:46:43 PM



Page 1

Item ID: PB67-43001-09

Accept



Setup Start



Revision ID:

Item Name: Aft Blade Fold Assembly Weldment

Stop



Start Date: 9/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *mtf*

Date: *10-9-24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-09

Rev C

100



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001 ** ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***

10-10-05 1

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

10-10-06

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10/10/06

(H)

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

10-10-6



Powdercoat

M 18144

0.00

①

Powder Coating

Memo

in detail D, mask in between -311 prior to paint[***mask 1.750" on the end of -243 prior to paint***[***mask inside of D3440-9 prior to paint***[START TIME:

400 FINISH TIME:

3.30

OVEN TEMPERATURE: 320°

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

10-10-15

1 P

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Required Date: 10/15/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18
MF
10-10-18

Picklist Print

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Work Order ID: 62309

Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 9/27/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec
10.09.24 per revC dwg EC verified by:DD

IPP RevB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

* PB67-43001-201		Manufactured	No			100	Each	0.0000	2	2			
------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Square Tube

PB67-43001-203		Manufactured	No			100	Each	1.0000	1	1			
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Square Tube

Location

Loc Qty

Loc Code

ST437 362105
41907

1

1

PB67-43001-209		Manufactured	No			100	Each	4.0000	1	1			
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Square Tube

Location

Loc Qty

Loc Code

ST437

4

4

PB67-43001-211		Manufactured	No			100	Each	12.0000	6	6			
----------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Square Tube

Location

Loc Qty

Loc Code

ST437

12

12

PB67-43001-213		Manufactured	No			100	Each	7.0000	2	2			
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Flanged Hook

Location

Loc Qty

Loc Code

ST438

7

7

52488



10.09.29 362104



10.09.28



10.09.28



10.09.28



10.09.28

2

Picklist Print

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Page 2

Work Order ID: 62309

Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 9/27/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-223

Manufactured

No

100

Each

44.0000

1

1

Square Cap

Location

Loc Qty

Loc Code

ST438

44

47504

44

100

Each

29.0000

4

4

PB67-43001-225

Manufactured

No

Bushing

Location

Loc Qty

Loc Code

ST438

29

44988

29

100

Each

54.0000

2

2

PB67-43001-227

Manufactured

No

Bushing

Location

Loc Qty

Loc Code

ST438

54

43712

22

44987

32

100

Each

4.0000

1

1

PB67-43001-229

Manufactured

No

Outer Tube

Location

Loc Qty

Loc Code

ST446

4

52487

2

54670

2

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 62309

Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 9/27/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

* PB67-43001-233 *Be one line only*
 Outer Tube End Cap
 Manufactured No
 W/A

100 Each

5.0000

1

1



10.09.28

Location

Loc Qty

Loc Code

ST446

5

41573

5

5

100 Each

0.0000

1

1



10.09.28 B 45260

* PB67-43001-235
 Outer Tube
 Manufactured No

PB67-43001-239
 Square Tube
 Manufactured No

100 Each

4.0000

1

1



10.09.28

Location

Loc Qty

Loc Code

ST438

4

44986

3

46633

1

1

100 Each

3.0000

1

1



10.09.28 343327

* PB67-43001-243
 Tube Handle Extension
 Manufactured No

Location

Loc Qty

Loc Code

ST446

3

43332

3

1

100 Each

0.0000

1

1



10.09.06 362110

* PB67-43001-277
 Contoured Male Eye
 Manufactured No

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Shop Packet Print

Page 3

Picklist Print

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Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 9/27/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-311

Manufactured No

100 Each

8.0000

2

2



Restraint



10.09.28

Location

Loc Qty

Loc Code

ST439A

8

62112

8

2

D3440-9

Manufactured No

100 Each

1.0000

1

1



Tube Detent Clip Base (Supersedes B67-43001-241)



10.09.28

Location

Loc Qty

Loc Code

ST441

1

41456

1

1

D3440-13

Manufactured No

100 Each

3.0000

1

1



Bracket (Supersedes B67-43001-273)



10.09.28

Location

Loc Qty

Loc Code

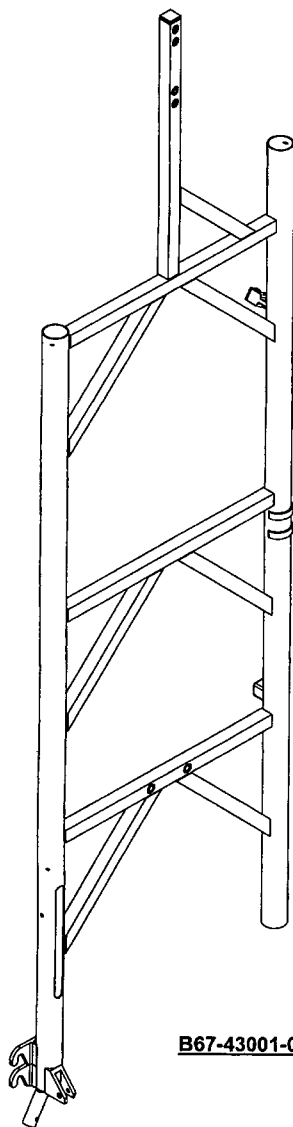
ST441

3

41452

3

1



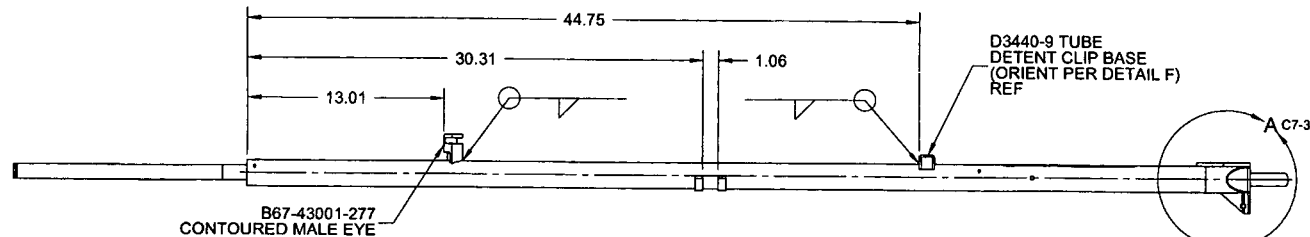
B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

ITEM	QTY -09	P/N	DESCRIPTION
1	X	B67-43001-09	AFT BLADE FOLD ASSEMBLY WELDMENT
2	2	B67-43001-201	SQUARE TUBE
3	1	B67-43001-203	SQUARE TUBE
4	1	B67-43001-209	SQUARE TUBE
5	6	B67-43001-211	SQUARE TUBE
6	2	B67-43001-213	FLANGED HOOK
7	1	B67-43001-223	SQUARE CAP
8	4	B67-43001-225	BUSHING
9	2	B67-43001-227	BUSHING
10	1	B67-43001-229	OUTER TUBE
11	1	B67-43001-233	OUTER TUBE END CAP
12	1	B67-43001-235	OUTER TUBE
13	1	B67-43001-239	SQUARE TUBE
14	1	B67-43001-243	TUBE HANDLE EXTENSION
15	1	B67-43001-277	CONTOURED MALE EYE
16	2	B67-43001-311	RESTRAINT
17	1	D3440-9	TUBE DETENT CLIP BASE
18	1	D3440-13	BRACKET

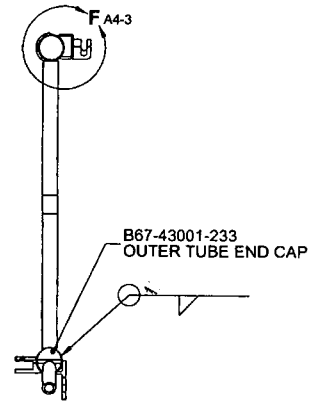
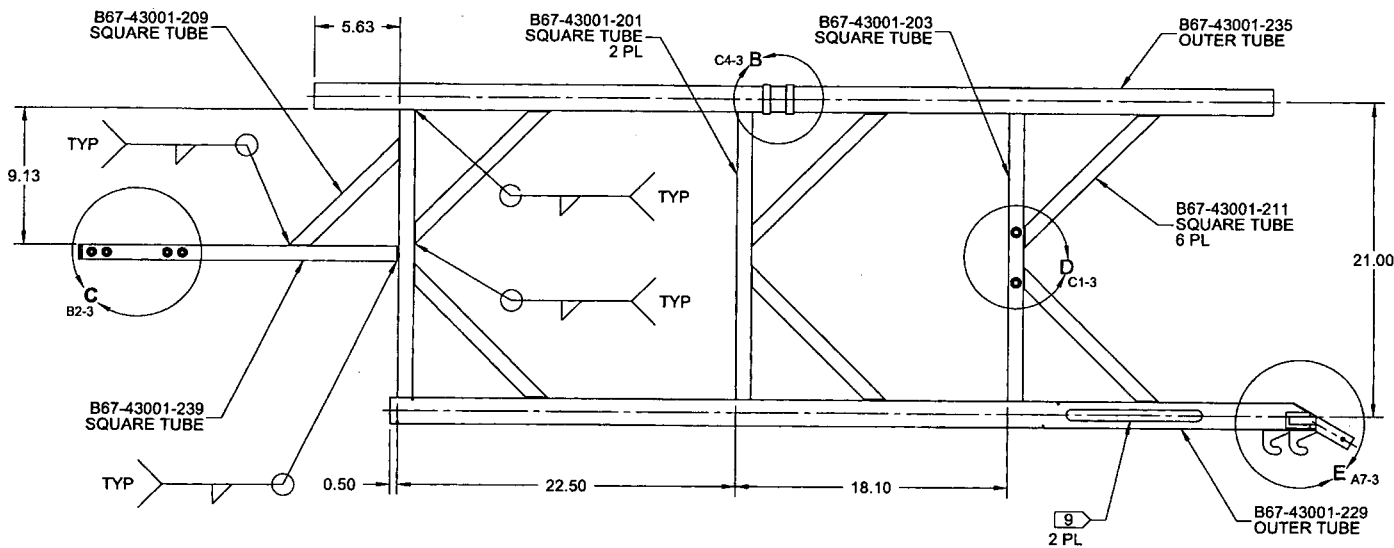
62309

RELEASED
2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 6 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.05.03
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO.	REV. C	
CHECKED		B67-43001-09	SHEET 1 OF 3	
MFG. APPR.		TITLE	SCALE	
APPROVED		AFT BLADE FOLD ASSY WELDMENT	NTS	
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	10.05.03			



62309



B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

RELEASED
2010-09-16

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 7.74 lbs
 - 8) WELDING: PER QSI 004
 - 9) MASKING: ALL OPENINGS AND INDICATED AREAS PRIOR TO POWDER COATING

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	B67-43001-09	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
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MATE WITH TOP SURFACE OF LOWER HOOK AND ALIGN WITH CENTERLINE OF OUTER TUBE

ALIGN WITH BOTTOM EDGE OF END CAP AND CENTERLINE OF OUTER TUBE

ALIGN WITH CENTERLINE OF OUTER TUBE AND FLUSH WITH ANGLED CUT

B67-43001-243 TUBE HANDLE EXTENSION REF

ALIGN WITH CENTERLINE OF OUTER TUBE AND TO BOTTOM SURFACE OF END CAP

D3440-13 BRACKET

DETAIL A D3-2
SCALE 4X

MASK ALL AROUND TUBE PRIOR TO POWDER COATING

B67-43001-311 RESTRAINT 2 PL

B67-43001-201 SQUARE TUBE REF

B67-43001-235 OUTER TUBE REF

DETAIL B C5-2
SCALE 4X

B67-43001-203 SQUARE TUBE REF

B67-43001-227 BUSHING 2 PL

B67-43001-211 SQUARE TUBE REF

DETAIL D B4-2
SCALE 4X

B67-43001-229 OUTER TUBE REF

MASK INSIDE SURFACES OF BRACKET PRIOR TO POWDER COATING

B67-43001-243 TUBE HANDLE EXTENSION

B67-43001-213 FLANGED HOOK 2 PL

MASK INSIDE SURFACE OF HOOK PRIOR TO POWDER COATING

DETAIL E B3-2
SCALE 4X

B67-43001-223 SQUARE CAP 2 PL

B67-43001-225 BUSHING 4 PL

B67-43001-239 SQUARE TUBE REF





DETAIL C B8-2
SCALE 4X

MASK INSIDE SURFACE AND HOLE (NOT SHOWN) OF CONTOURED MALE EYE PRIOR TO POWDER COATING

D3440-9 TUBE DETENT CLIP BASE MASK THREADED HOLE (NOT SHOWN) PRIOR TO POWDER COATING

DETAIL F C2-2
SCALE 4X

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2010-09-16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-09	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
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